

**This Page Is Inserted by IFW Operations  
and is not a part of the Official Record**

## **BEST AVAILABLE IMAGES**

**Defective images within this document are accurate representations of the original documents submitted by the applicant.**

**Defects in the images may include (but are not limited to):**

- **BLACK BORDERS**
- **TEXT CUT OFF AT TOP, BOTTOM OR SIDES**
- **FADED TEXT**
- **ILLEGIBLE TEXT**
- **SKEWED/SLANTED IMAGES**
- **COLORED PHOTOS**
- **BLACK OR VERY BLACK AND WHITE DARK PHOTOS**
- **GRAY SCALE DOCUMENTS**

**IMAGES ARE BEST AVAILABLE COPY.**

**As rescanning documents *will not* correct images,  
please do not report the images to the  
Image Problem Mailbox.**

(19)



Europäisches Patentamt  
European Patent Office  
Office européen des brevets



(11)

**EP 0 645 044 B1**

(12)

**EUROPEAN PATENT SPECIFICATION**

(45) Date of publication and mention  
of the grant of the patent:  
**12.08.1998 Bulletin 1998/33**

(51) Int Cl.<sup>6</sup>: **G11B 20/14, G11B 21/02,  
G11B 5/596, G11B 5/74,  
G11B 5/82**

(21) Application number: **93925177.3**

(86) International application number:  
**PCT/US93/05646**

(22) Date of filing: **10.06.1993**

(87) International publication number:  
**WO 93/26007 (23.12.1993 Gazette 1993/30)**

(54) **STEERING LASER BEAM WHILE ETCHING OPTICAL SERVO TRACKS FOR MAGNETIC DISKS**

**STEUERUNG EINES LASERSTRAHLS WÄHREND DER ÄTZUNG VON OPTISCHEN  
SERVOSPUREN FÜR MAGNETPLATTEN**

**ORIENTATION D'UN FAISCEAU LASER PENDANT LA GRAVURE DE PISTES OPTIQUES  
ASSERVIES DE DISQUES MAGNETIQUES**

(84) Designated Contracting States:  
**DE FR GB**

• **WILSON, Scott**  
**Westminster, CO 80030 (US)**

(30) Priority: **10.06.1992 US 896188**

(74) Representative: **VOSSIUS & PARTNER**  
**Siebertstrasse 4**  
**81675 München (DE)**

(43) Date of publication of application:  
**29.03.1995 Bulletin 1995/13**

(73) Proprietor: **MINNESOTA MINING AND  
MANUFACTURING COMPANY**  
**St. Paul, Minnesota 55133-3427 (US)**

(56) References cited:  
**US-A- 4 130 898                      US-A- 4 633 451**  
**US-A- 4 831 470                      US-A- 4 935 835**  
**US-A- 4 961 123                      US-A- 5 067 039**  
**US-A- 5 162 955**

(72) Inventors:

- **THOMAS, Fred, Charles**  
**Kaysville, UT 84037 (US)**
- **WALLENTINE, Don, W.**  
**Layton, UT 84040 (US)**
- **BERO, James**  
**Ogden, UT 84403 (US)**

- **Spie Optical Data Storage Topical Meeting, 1989,**  
**GOODIN, J., "An Introduction to the Insite Disc**  
**Drive", Vol. 1078, pp. 71-79.**
- **Optoelectronics: An Introduction, J. WILSON**  
**and J.F.B. HAWKES, Prentice Hall, 1983, pp. 111**  
**to 116.**

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent grant. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

**EP 0 645 044 B1**

## Description

This invention relates to etching optical servo tracks on magnetic disks and more particularly, to steering the laser beam while mechanically moving the optics to etch the servo tracks in the desired concentric patterns.

So-called "floppy" disk memory systems for "desk top" sized computers are well known in the art. Such systems employ magnetic storage disks having a diameter of either 5.25 inches (130 mm) or 3.50 inches (89 mm). Conventional magnetic storage disks for floppy disk drives have a track density ranging from forty-eight (48) to one hundred thirty-five (135) tracks per inch (TPI) (i.e., 1.9 to 5.3 tracks/mm). In contrast, optical storage disks for optical memory systems achieve track densities greater than 15,000 TPI (590 tracks/mm). The greater track density of optical disks is achieved by the use of optical servos that maintain fine positioning of the optical read/write head over the data tracks on the disk. Typically, concentric optical servo tracks are pre-recorded on the optical disk to guide the servo mechanism.

New advances in barium-ferrite magnetic media have allowed bit densities of magnetic storage disks to exceed the bit densities of the optical disks. However, as mentioned above, track densities of magnetic media (48 - 135 TPI i.e., 1.9 to 5.3 tracks/mm) are many times less than their optical counterparts. This limits the overall capacity of the magnetic disks as compared to optical disks. Conventional magnetic disk systems employ a magnetic servo mechanism and magnetically pre-recorded servo tracks on the disks to guide the read/write head. Magnetic servo systems cannot provide the fine positioning that optical servo systems can provide.

Recently, floppy disk systems have been developed that combine magnetic disk recording techniques with the high track capacity optical servos found in optical disk systems. Such a system is described in AN INTRODUCTION TO THE INSITE 325 FLOPTICAL(R) DISK DRIVE, Godwin, in a paper presented at the SPIE Optical Data Storage Topical Meeting (1989). Essentially, an optical servo pattern is pre-recorded on a magnetic floppy disk. The optical servo pattern typically consists of a large number of equally spaced concentric tracks about the rotational axis of the disk. Data is stored in the magnetic "tracks" between the optical servo tracks using conventional magnetic recording techniques. An optical servo mechanism is provided to guide the magnetic read/write head accurately over the data between the optical servo tracks. By utilizing optical servo techniques, much higher track densities are achievable on the relatively inexpensive removable magnetic medium.

As mentioned, the optical servo pattern typically consists of a large number of equally spaced concentric tracks about the rotational axis of the disk. As disclosed in U.S. Patent 4,961,123, each track may be a single continuous groove (Fig. 3) a plurality of equally spaced circular pits (Fig. 8) or a plurality of short equally spaced

grooves or stitches (Fig. 9). Various methods and systems exist for inscribing the optical servo tracks on the magnetic medium.

For example, U.S. Patent No. 5,067,039, entitled "High Track Density Magnetic Media With Pitted Optical Servo Tracks and Method for Stamping the Tracks on the Media", discloses a method for "stamping" the servo tracks on the magnetic medium. Essentially a master stamping disk is produced bearing a template of the optical servo pattern. This master disk is then pressed against the magnetic floppy disk under a pressure of several tons per square inch. The significant amount of pressure transfers the servo track pattern from the master disk to the floppy.

U.S. Patent No. 4,633,451, entitled "Optical Servo for Magnetic Disks", discloses a method of providing optical servo information on a magnetic medium consisting of a multi-layer film. The optical servo tracks are formed on the multi-layer film by laser heating the structure to cause a reaction or interdiffusion to occur between layers. The reaction produces a reflectivity contrast of about eight percent (8%) between exposed and unexposed areas. Other methods for preparing the servo tracks are mentioned including contact printing, embossing, and lithography.

U.S. Patent No. 4,961,123 entitled "Magnetic Information Media Storage with Optical Servo Tracks," discloses a preferable method and apparatus for etching the pattern on a disk using a focused beam of light. The magnetic disk is placed on a platen/spindle assembly and rotated. A beam of light is focused to a small spot on the spinning disk. The focused beam has sufficient intensity to ablate the disk surface at the point of incidence, thereby reducing the reflectivity of the surface at that point. The beam can be left on during an entire revolution to produce a continuous groove or can be modulated on and off through one revolution to produce a stitched pattern. This method has several advantages. First, the intensity of the focused beam of light can be adjusted for different types of magnetic media. Secondly, different stitched patterns can be etched simply by varying the on-off time of the beam or by varying the speed of rotation of the disk. Additionally, there is no need to produce a master disk, as with the stamping method.

As mentioned above, the optical servo pattern often comprises a number of equally spaced concentric optical servo tracks about the rotational axis of the disk. A single disk may have as many as 900 concentric servo tracks. Additionally, each optical servo track may be a continuous groove, or alternatively, may comprise a plurality of equally spaced stitches. When a stitched pattern is employed, the number of stitches in each optical servo track may exceed 1600 with each track having the same number of stitches. It is crucial for proper servo positioning that every stitch be sufficiently detectable by the servo optics. As mentioned, a preferred method of producing a stitched pattern is by focusing a beam of light on

a rotating disk and modulating the beam on and off. The beam, when incident upon the surface of the disk and properly focused, has sufficient intensity to etch the surface thereby creating a stitch having reduced reflectivity.

The prior art approach to creating these tracks is to position the laser optics directly over the cylinder to be etched. Then the beam is modulated using a clock source controlled by the rotation of the disk. This technique has been successfully used but it has a low throughput and requires high maintenance for the moving optics and mechanical elements. This is because the optical system must be accelerated and decelerated into position almost 1,000 times for each disk. These prior art recording techniques for optical servo tracks do not allow flexible recording patterns.

The objects of the present invention are solved by the features of the claims.

In accordance with the present invention, a beam of light used to etch servo tracks on a magnetic disk is steered with an acousto-optical device to maintain the beam in concentric circular patterns while mechanically moving the optics which generate the beam of light continuously radially of the disk. Concentric tracks are etched by steering the laser beam in a manner which compensates for the continuous mechanical movement of the beam by the optics.

Sets of digital signals are stored in a random access memory for controlling the steering. Sets of these digital signals are selected under microprocessor control and in response to the radial position of the beam. These sets of signals are applied to the acousto-optical device to maintain the beam in concentric patterns. Moving the optical system at a constant speed while steering the zero mass laser beam with a suitable acousto-optical device eliminates many of the problems of the prior art. The laser beam is steered into cylinder format from the natural spiral format which would have resulted without steering. The steering is directed with a closed loop system that evaluates the position of the optics relative to the disk, extracts the steering data from a memory based table and sends the data to the acousto-optical controller for the laser beam. In accordance with the invention, the steering voltage needed to keep the beam centered over a cylinder of constant radius is memory-mapped. Then, the memory-mapped signals are used to steer the laser beam thereby eliminating the time to seek and settle the optical components otherwise required to focus the beam onto the media.

In accordance with another feature of the present invention digital intensity signals are stored in another random-access memory and are retrieved from the memory under microprocessor control and in response to the radial position of the beam. The intensity signals are applied to the acousto-optical device to vary the intensity of the incident beam to maintain a constant energy density delivered by the beam at all radii of the disk.

A laser Doppler meter is used to encode the radial position of the optics relative to the disk. The encoded

position is used as the address for the random access memories containing the intensity and steering signals. The memory-mapped approach of the present invention gives flexibility to the type and rate of servo patterns that can be recorded.

The foregoing summary, as well as the following detailed description of the preferred embodiment, is better understood when read in conjunction with the appended drawings. For the purpose of illustrating the invention, there is shown in the drawings, an embodiment that is preferred, it being understood, however, that the invention is not limited to the specific methods and instrumentalities disclosed. In the drawings:

Figure 1 is a top view of a magnetic disk having concentric magnetic data tracks and concentric optical servo tracks each comprised of a plurality of equally spaced etched stitches;

Figure 2 is a cross-sectional view of the magnetic disk of Figure 1 taken along line 2--2 of Figure 1;

Figure 3 is an enlarged top view of a portion of the magnetic disk of Figure 1 showing the etched stitches in greater detail;

Figure 4 is a block diagram of an apparatus for etching optical servo information on a magnetic medium and for steering the incident beam in accordance with the present invention;

Figure 5 is a graphical illustration of steering an incident beam in accordance with the present invention;

Figure 6 is a block diagram showing further details of the acousto-optical device of Figure 4 in accordance with the present invention.

Referring to the drawings in detail, wherein like numerals indicate like elements throughout, there is shown in Figure 1 a top view of a magnetic disk 10 having concentric optical servo tracks 12 about the rotational axis 16 of the disk 10. Each servo track 12 is comprised of a plurality of equally spaced etched stitches 18. Concentric magnetic data tracks 20 (i.e., non-etched regions) lie between each adjacent pair of servo tracks 12 for magnetically recording data on the disk 10. In the preferred embodiment, the disk 10 has 900 concentric servo tracks 12 and each servo track 12 comprises 1666 equally spaced etched stitches 18.

Referring now to Figure 2 there is shown a cross-sectional view of the magnetic disk 10 of Figure 1 taken along line 2--2 of Figure 1. The disk 10 comprises a substrate 22 having a thickness T, and a magnetic coating 24 on the surface of the substrate 22. The magnetic coating 24 has a thickness t. As described more fully below, the stitches or grooves 18 are formed by etching the magnetic coating 24 with a beam of light. Once etched, the stitches 18 are indelible. Each groove or stitch 18 in each servo track 12 has a width w and a depth d. Although the stitches 18 are illustrated in Figure 2 as having a well-defined, almost uniform depth d, they

need not be so uniform. For example, each stitch may simply be a rough "scarred" region on the surface of the magnetic coating. The non-etched regions that define the magnetic data tracks 20 have a width  $m$  that represents the spacing between adjacent optical servo tracks 12.

The stitches or grooves 18 define a plurality of concentric optical servo tracks 12 each having a radius  $r$  as measured from the rotational axis 16 of the disk 10 to the center of the etched stitches 18. As shown in Figure 2, the outer-most radius is designated  $r_o$  and the inner-most radius is designated  $r_i$ . Similarly, the non-etched regions between adjacent servo tracks 12, which form the concentric magnetic data tracks 20, have a radius  $x$  as measured from the axis 16 of the disk 10 to the center of the data track 20.

Referring now to Figure 3, there is shown an enlarged top view of a portion of the magnetic disk 10 of Figure 1. As shown in Figure 3, the stitches 18 in each servo track 12 have a length  $l_n$  and consecutive stitches in a given track 12 have a spacing  $s_n$  between them. In the preferred embodiment, for each track, the length  $l_n$  of each stitch and the spacing  $s_n$  between consecutive stitches is equal; however, the length  $l_n$  may be greater or smaller than the spacing  $s_n$  between consecutive stitches.

As mentioned above, each optical servo track 12 comprises an equal number of stitches 18, which in the preferred embodiment is 1666. Because the radius  $r$  of the servo tracks 12 decreases from the outer- to inner-most track, in order to maintain the same number of stitches 18 per track, the stitch spacing  $s_n$  and stitch length  $l_n$  must decrease from the outer- to the inner-most track.

In the preferred embodiment, each stitch 18 has a width  $w$  of approximately 4.8 microns, and the optical servo tracks 12 are laid down every 20.4 microns on the disk.

Referring to Fig. 4, there is shown a preferred embodiment of an apparatus 39 for etching the surface of a magnetic medium to reduce the reflectivity thereof and to produce concentric servo tracks. More particularly, the apparatus 39 is for etching a plurality of concentric optical servo tracks about the rotational axis of a magnetic storage disc, such as is shown in Fig. 1, wherein each track comprises a plurality of equally spaced etched stitches.

As shown in Fig. 4, the apparatus 39 comprises a light source 40 for providing an incident beam of light 42. The light source 40 has means (not shown) for linearly polarizing the incident beam of light in a first polarizing direction. The direction of linear polarization, i. e., the first polarizing direction, is not critical. In the preferred embodiment, the light source 40 is a laser tuned to a wavelength suitable for etching the surface of the magnetic medium. Thus, the incident beam is highly collimated and monochromatic. Different wavelengths may be used with magnetic media having different charac-

teristics. Two Brewster windows (not shown) in the laser tube comprise the means for linearly polarizing the incident beam.

The apparatus 39 also comprises an acousto-optical device 44 for adjusting the intensity of the incident beam and for steering the beam for reasons which will become evident hereinafter. Acousto-optical devices are described generally in Wilson & Hawkes, OPTOELECTRONICS: AN INTRODUCTION, pp. 111 to 116 (Prentice/Hall 1983). The Acousto-optical (AO) device 44 is described hereinafter in greater detail. Briefly, the device 44 accepts digital frequency data at a first input 43 and analog voltage data at a second input 45. The frequency data and voltage data control the frequency and amplitude, respectively, of an ultrasonic wave applied to a birefringent crystal in the device 44 which changes the index of refraction of the crystal in one direction. Changes in the frequency of the ultrasonic wave produce deflections of the incident beam as it travels through the crystal. Changes in the amplitude of the ultrasonic wave create corresponding changes in the intensity of the beam.

Mirror 50 directs the linearly polarized incident beam through a beam separator 52. Beam separator 52 has means for transmitting light linearly polarized in the first polarizing direction (as is the incident beam) and for deflecting light linearly polarized in a direction orthogonal to the first polarizing direction. In the preferred embodiment, the means for transmitting light linearly polarized in the first polarizing direction and for deflecting light polarized orthogonal thereto is a multilayer dielectric thin film laser line coating 53 positioned along the hypotenuse of the beam separator 52.

The beam separator 52 transmits the linearly polarized incident beam and mirrors 51, 55 direct the transmitted incident beam to an objective lens 54. The lens 54 focuses the incident beam to a spot 57 on a magnetic storage disk 61 to be etched. In the preferred embodiment, the focused spot 57 is substantially circular, however it need not be substantially circular; for example, the focused spot could be oblong in shape.

A platen/spindle assembly 59 rotates the disk 61 about its rotational axis. The lens 54 is positioned such that the rotating disc lies substantially in the focal plane of the lens 54. The focused incident beam reacts with the rotating magnetic medium 61 at the spot 57 to create a stitch (not shown) on the medium 61 having reduced reflectivity. A portion of the focused incident beam is reflected. Since the incident beam is focused to a fine spot on the magnetic medium, the reflected light effectively emanates from a point source. As described above, the rotating disk 61 lies in the focal plane of the lens 54, and therefore, the point source of reflected light lies at the focal point of the lens 54. Consequently, the lens 54 operates to collimate the reflected light and direct a reflected beam back toward the beam separator 52 via the mirrors 51, 55. The reflected beam is used for verification as is more fully described in WO 93/26004, entitled "Ap-

paratus for and Method of Verifying Etching of Optical Servo Information on Magnetic Media."

A voice coil actuator 72 moves the optics 71 which generate the beam of light so that the beam moves radially of the disk for etching each of the concentric servo tracks. In the preferred embodiment, the beam of light is moved continuously radially of the disk 61. The actuator 72 is moved by a closed loop positioning system which comprises up/down count generator 75, counter 76, digital-to-analog converter 77 and laser Doppler meter 79. To initiate movement, microprocessor 81 loads a value into the up/down count generator 75. The up/down count generator 75 produces a pulse train having a given number of pulses at a given velocity for indicating desired position. These pulses increment or decrement the counter 76 depending upon the desired direction of movement. The output of the counter 76 drives the digital-to-analog converter 77 which generates an error voltage. An amplifier 78 provides compensation and current amplification. Amplifier 78 causes current to flow in the voice coil actuator 72, causing the actuator 72 to move in the desired direction. This movement is detected by the laser Doppler meter 79, which feeds back the new position. This signal causes the counter 76 to increment or decrement back to the zero position.

As mentioned, in the preferred embodiment, the 5 incident beam is moved continuously radially of the disk 61. Prior art methods of etching concentric servo tracks keep the incident beam still while etching a given track and only move to reposition the incident beam for etching the next track. By moving the incident beam continuously radially of the disk, the present invention increases throughput. Because the optics 71 which generate the incident beam are continuously moving radially of the disk, the acousto-optical device 44 is used to steer the incident beam in order to maintain the beam in the concentric pattern of the track being etched.

Referring briefly to Figure 5, there is shown a graphical illustration of the method of beam steering in accordance with the present invention. As illustrated, adjacent optical servo tracks 12 have a track-to-track spacing,  $d_t$ . As mentioned previously, in the preferred embodiment,  $d_t$  is approximately 20.4 microns. Thus, the optics 71 move continuously radially (in the direction of the arrow) through a distance of 20.4 microns during the etching of each track. Consequently, the incident beam must be steered at an angle  $\alpha$  in order to maintain the beam in the concentric pattern of the track 12 being etched. As illustrated, the steering angle  $\alpha$  is a function of the radial position of the optics 71 relative to the disk 61.

Referring once again to Figure 4, the radial position of the optics 71 during the etching of a given servo track (i.e., an etch cycle) is encoded by the laser Doppler meter 79. A bi-directional laser beam 65 that strikes a retro-reflector 63 on the optics 71 provides positioning information to the laser Doppler meter 79. The resolution of the laser Doppler meter 79 is adjustable. In the preferred embodiment, the laser Doppler meter 79 is adjusted to

discern movement of the optics 71 in increments of  $1/516$  of the track-to-track distance  $t_d$ . As the optics 71 move radially through each  $1/516$ th increment during the etching of a track, the laser Doppler meter 79 increments a track position counter 85. The track position counter 85, therefore, maintains a count which indicates the radial position of the optics 71 during an etch cycle. The counter 85 is reset at the beginning of each etch cycle.

From the radial position information provided by the track position counter 85, the steering angle  $\alpha$  can be calculated. Circuitry could be provided to continuously re-calculate the beam angle  $\alpha$  and provide a proper steering signal to the acousto-optical device 44. Such circuitry, however, would be complex and difficult to implement. In accordance with the present invention, a memory-mapped technique is used.

Acousto-optical device 44, which is used to steer the beam, is controlled by sets of digital steering signals retrieved from a first random-access-memory (RAM) 98. Each digital steering signal stored in the first RAM 98 represents the beam angle  $\alpha$  required for a particular radial position of the optics 71 during an etch cycle. In the preferred embodiment, there are 516 steering signals stored in the first RAM 98 - one for each of the 516 positions encoded by the laser Doppler meter 79 during an etch cycle. The output of the track position counter 85 provides the memory address of the appropriate stored signal for a given radial position. The acousto-optical device 44 responds to the retrieved steering signals to steer the beam to maintain the beam in the concentric pattern of the track being etched.

According to the present invention, the spindle 59 rotates the magnetic disk 61 at a constant speed (rpm). With a constant rotational speed, the energy density, ED, delivered by the incident beam to the spot 57 on the disk 61 will vary at different track radii. If not corrected, this will result in unacceptable stitch width variations. The energy density, ED, delivered by the beam is proportional to the intensity of the beam,  $I_o$ , within the focused spot 57 divided by the area of the spot 57,  $A_o$ , multiplied by the linear velocity  $V_l$  of the disk 61 at the focused spot 57. That is,

$$ED \propto \frac{I_o}{A_o V_l}$$

In accordance with the present invention, as the optics which generate and focus the incident beam are moved radially of the disk to etch different servo tracks, the intensity  $I_o$  of the incident beam is adjusted with an acousto-optical device to maintain a substantially constant energy density delivered by the incident beam at all radii. Specifically, acousto-optical device 44 is used to adjust the intensity of the beam. This method of beam intensity adjustment is the subject of WO 93/25341, entitled "Acousto-Optical Intensity Control of Laser Beam

During Etching of Optical Servo Information on Magnetic Media."

The AO device 44 is controlled by sets of digital intensity signals retrieved from a second random-access-memory (RAM) 90. The sets of digital intensity signals are selected under control of microprocessor 81 and in response to the radial position of the incident beam relative to the disk 61. The digital intensity signals are converted to an analog voltage signal by a digital-to-analog converter (DAC) 92. For purposes described more fully below, the analog voltage signal passes through an analog switch 94 which performs a gating function in response to the output of a third random-access-memory (RAM) 96. The analog voltage signal then passes from switch 94 to the AO device 44. The AO device 44 is responsive to the amplitude of the analog signal from DAC 92 to adjust the intensity of the incident beam transmitted through the device 44.

The digital intensity signals are stored in a table in the second RAM 90 as a function of the radial position of the beam. In addition, beam steering angle can affect the energy density delivered by the beam and therefore can also affect stitch width. Consequently, the intensity signals are also a function of beam steering angle. The intensity signals are retrieved and applied (in the form of an analog signal) to the device 44 using a memory-mapped approach similar to that described above for the steering signals.

As mentioned above, in the preferred embodiment, there are 900 concentric servo tracks each having a unique radius  $r_n$ . Thus, to compensate for the different radii, potentially 900 different intensity signals could be stored in the second RAM 90 - one for each track. As described previously, however, the beam is steered through 516 angles during the etching of a given track and each angle requires an intensity adjustment as well.

Because the beam is steered through the same set of angles for each track, the intensity adjustment factor based on angle will repeat for every track. However, the overall intensity value during the etching of each track must vary to compensate for the different radii. Thus, to compensate for both beam angle and track radius, 516 unique intensity signals might be stored for each of the 900 servo tracks - each signal representing an adjustment factor based on steering angle and an adjustment factor based on track radius. The cost of memory required for such a large number of signals may be prohibitive.

Consequently, in the preferred embodiment, the intensity adjustment factor based on track radius is held constant for groups of adjacent tracks. For each group, the intensity adjustment factor is averaged over the entire group and remains constant. Thus, the same 516 intensity signals are used for each track in the group and the change in radius within the group is ignored. This is acceptable because adjacent servo tracks are relatively close together (20.4 microns) and therefore have relatively similar radii. Using the same 516 intensity signals

for a group of adjacent tracks does not result in unacceptable stitch width so long as the size of the group is small enough that stitch width stays within accepted tolerances.

In the preferred embodiment, there are 16 tracks to a group. Each time the track position counter 85 is reset, a track is counted by the track group counter 84. The output of the track group counter 84 and track position counter 85 are combined to form the data address for the intensity signals stored in the second RAM 90. Thus, for each group of 16 tracks, the track group counter 84 and track position counter 85 combine to address a set of 516 intensity signals for the tracks in that group. As the beam is used to etch the disk 61 from the outside to the inside of the disk 61, the overall intensity for each group is reduced as the beam moves from the outside to the inside groups of tracks. Although in the preferred embodiment the intensity of the beam is varied according to groups of servo tracks, if sufficient memory is available, the intensity may be varied on a track-to-track basis.

As mentioned, the retrieved intensity signals are fed to digital-to-analog converter 92 which produces an analog voltage signal having an amplitude which varies in proportion to the retrieved intensity signals. The analog signal is fed through switch 94 to the analog input 45 of the AO device 44. The AO device is responsive to the analog voltage signal to alter the intensity of the incident beam in proportion to the amplitude of the voltage signal. By altering the intensity of the incident beam to compensate for the change in radial position of the optics 71 relative to the disk 61 and to compensate for the change in beam angle, the present invention maintains a substantially constant energy density delivered by the beam to the disk during the entire etching of the disk.

In accordance with another feature of the present invention, the beam is modulated on and off during an etch cycle to produce the stitched pattern of the optical servo tracks. As mentioned, in the preferred embodiment, there are 1666 equally spaced stitches in every servo track. Thus, the incident beam must be modulated on and off as the disk 61 rotates past the beam in order to create the stitched etched pattern. To this end, the angular position of the spindle 59 is encoded with a motor shaft encoder 73. Motor shaft encoder 73 produces 1666 individual pulses during one revolution which indicate the angular position of the spindle 59. The output of the encoder 73 is applied to a phase lock loop 82 which multiplies the frequency digitally, but keeps the output in phase with the shaft encoder 73. In the example under consideration, the output of the phase lock loop 82 is at 64 times the frequency of the output of motor shaft encoder 73. This increases the angular resolution of the encoder to 1/64th of a stitch. The phase lock loop signal is applied to angle counter 83 which increments in response to the pulses output by the phase lock loop 82. Thus, the digital value in the angle counter 83 represents the angular position of the disk 61 during

an etch cycle. The counter 83 is reset once a revolution.

The output of counter 83, which indicates the angular position of the disk 61, provides a memory address to a third random-access-memory (RAM) 96. The third RAM 96 contains sets of digital pattern signals for modulating the incident beam on and off. Specifically, the pattern signals are stored in a table in the third RAM 96 as a function of the angular position of the disk 61 during an etch cycle. The signals stored in the third RAM 96 indicate whether the incident beam should be on or off at a given angular position. The output of third RAM 96 controls the analog switch 94. Thus, at a given angular position, a pattern signal is addressed and retrieved from the third RAM 96. The retrieved signal represents either beam-ON or beam-OFF. If the retrieved signal represents beam-ON, the switch 94 is closed allowing the analog intensity signal from the DAC 92 to pass to the input 45 of the AO device 44. If however, the retrieved pattern signal represents beam-OFF, the switch 94 is opened and a one-volt signal is applied to the input 45 of the AO device 44. A one-volt signal applied to the input 45 of the device 44 effectively turns the beam off. In this manner, the on-off duty cycle of the beam is controlled to obtain the desired stitch pattern for each servo track.

As mentioned above, in the preferred embodiment, the length of each stitch  $l_n$  and the spacing  $s_n$  between consecutive stitches in each track is equal - a 50% duty cycle. As mentioned, however, the phase lock loop 82 and angle counter 83 provide an angular resolution of approximately  $1/64$  of a stitch. Thus, by altering the pattern of signals in third RAM 96, the stitch pattern is highly customizable.

The memory-mapped approach to controlling the steering, intensity and on-off pattern of the incident beam achieves great flexibility and allows the apparatus 39 to be easily adapted for different etched servo track patterns and disk sizes. Microprocessor 81 and other logic (not shown) provide overall control of memory addressing and timing functions.

Referring now to Figure 6, the acousto-optical device 44 of Figure 4 is shown in greater detail. The device 44 accepts the 16-bit digital signals retrieved from RAM 98 (Figure 4) at a first input 43. The device 44 accepts the analog voltage signal from switch 94 (Figure 4) at a second input 45. The 16-bit digital signals (i.e., words) are received by control electronics 100 and fed to a digital/direct frequency synthesizer 102. The frequency synthesizer 102 produces a fixed amplitude oscillating signal having a frequency which varies in response to, and proportional to, the digital values of the 16-bit signals from the RAM 98 (Figure 4). The oscillating signal is fed to modulator/mixer circuit 104.

The analog voltage signal is received by control electronics 106 which condition the signal and pass the signal to the modulator 104. The amplitude of the analog voltage varies from 0 to 1 volts. The modulator/mixer 104 amplitude modulates the oscillating signal from the

synthesizer 102 with the analog voltage signal. The output of modulator/mixer 104 is fed to amplifier 108 which amplifies the signal and feeds it to a transducer 110 which is coupled to a bi-refrangent crystal 112. The transducer 110 produces an ultrasonic wave having the same frequency/amplitude characteristics as the electronic signal from the modulator/mixer 104. The ultrasonic wave is applied to the birefringent crystal 112. The incident beam is directed through the crystal 112. The ultrasonic wave changes the index of refraction of the crystal in one direction. The frequency of the ultrasonic wave controls deflection or steering of the incident beam as it travels through the crystal, while the amplitude of the ultrasonic wave controls the intensity of the beam that exits from the crystal.

Thus, as described above, the 16-bit digital signals from RAM 98 (Figure 4) control the steering angle of the incident beam as it passes through the device 44. The analog signal generated by the digital-to-analog converter 92 in response to the digital signals retrieved from RAM 90 controls the intensity of the incident beam.

The device 44 was manufactured by Neos Corp., Melbourne, FL. Typically, acousto-optical devices use a voltage controlled oscillator (VCO) to control the frequency of the signal fed to the transducer 110. In accordance with the present invention, however, the typically employed VCO was replaced with the digital/direct frequency synthesizer 102. The synthesizer 102 achieves a much higher frequency stability, and therefore beam steering stability, over time and temperature. Such enhanced frequency/steering stability is necessary to achieve the tight stitch width and placement tolerances required in accordance with the present invention.

While a particular embodiment of the invention has been shown and described, various modifications of the invention are within the scope of the invention. The appended claims are, therefore, intended to cover all such modifications.

## Claims

1. A method of etching a plurality of concentric circular optical servo tracks (12) about the rotational axis of a magnetic storage disk (61) in relation to magnetic tracks (20) on said disk comprising:
  - generating a beam of light for etching each of said optical servo tracks;
  - characterized by

mechanically moving the optics (71) which generate said beam of light so that said optics (71) move continuously radially of said disk; and steering said beam of light in a radial direction of said disk with an acousto-optical device (44) as the optics (71) move continuously radially of the disk to maintain said beam in a concentric



circular pattern on the disk while etching each of said concentric circular optical servo tracks.

2. The method recited in claim 1 wherein the steps of steering comprise:

storing sets of digital steering signals for controlling said steering;  
selecting said sets under microprocessor control and in response to the radial position of said beam; and  
applying said sets of signals to said acousto-optical device to maintain said beam in concentric patterns.

3. The method recited in claim 2 further comprising:

rotating said disk on a spindle as said servo tracks (12) are etched;  
encoding the radial position of said optics to produce a signal representing the radial position of said optics (71) relative to said spindle (59); and  
applying said signal representing radial position to select the stored digital steering signals.

4. The method recited in claim 1 wherein the step of mechanically moving the optics (71) comprises:

moving said optics (71) with a voice coil actuator (72); and  
feeding back positional information in closed loop control of said voice coil actuator (72).

5. The method recited in claim 1 further comprising:

storing sets of digital intensity signals for controlling the intensity of said beam of light; and  
applying said digital intensity signals to said acousto-optical device to control the intensity of said beam.

6. The method recited in claim 5 further comprising:

rotating said disk on a spindle (59) as said servo tracks (12) are etched;  
encoding the radial position of said optics to produce a signal representing the radial position of said optics (71) relative to said spindle (59); and  
applying said signal representing radial position to select the stored digital intensity signals.

7. Apparatus for etching a plurality of concentric circular optical servo tracks (12) about the rotational axis of a magnetic storage disk (61) in relation to magnetic tracks (20) on said disk comprising:

optics (71) for generating a beam of light for

etching each of said optical servo tracks (12);  
characterized by

means for mechanically moving said optics (71) which generate said beam of light so that said optics move continually radially of said disk; and  
an acousto-optical device (44) for steering said beam of light in a radial direction of said disk as the optics (71) move continuously radially of the disk to maintain said beam in a concentric circular pattern on the disk while etching each of said concentric circular optical servo tracks (12).

8. The apparatus recited in claim 7 further comprising:

a memory (98) for storing sets of digital steering signals for controlling said steering;  
a microprocessor (81) for selecting sets of said digital steering signals in response to the radial position of said beam relative to said disk; and  
means for applying said sets of digital signals to said acousto-optical device (44) to maintain said beam in concentric patterns.

9. The apparatus recited in claim 8 further comprising:

a spindle (59) for rotating said disk;  
an encoder (79) for encoding the radial position of said optics (71) relative to said spindle (59); and  
means for applying said signal representing radial position to select the stored digital steering signals.

10. The apparatus recited in claim 7 wherein said means for mechanically moving said optics comprises:

a voice coil actuator (72); and  
a closed loop feedback control (75, 76, 77, 79) for feeding back positional information to said voice coil actuator (72).

11. The apparatus recited in claim 7 further comprising:

a memory (90) for storing sets of digital intensity signals for controlling the intensity of said beam of light; and  
means (92, 94) for applying said digital intensity signals to said acousto-optical device (44) to control the intensity of said beam.

12. The apparatus recited in claim 11 further comprising:

a spindle (59) for rotating said disk;

an encoder (79) for encoding the radial position of said optics (71) relative to said spindle (59); and means for applying said signal representing radial position to select the stored digital intensity signals.

Bewegen der Optik (71) mittels einer Schwing-spulen-Betätigungseinrichtung (72); und Zurückführen einer Positionsinformation in einem geschlossenen Regelkreis der Schwing-spulen-Betätigungseinrichtung (72).

#### Patentansprüche

1. Verfahren zum Ätzen mehrerer konzentrischer kreisförmiger optischer Servospuren (12) um die Rotationsachse einer magnetischen Speicherplatte (61) in Bezug auf magnetische Spuren (20) auf der Platte, mit:

Erzeugen eines Lichtstrahls zum Ätzen jeder der optischen Servospuren;  
gekennzeichnet durch:

mechanisches Bewegen der Optik (71), welche den Lichtstrahl erzeugt, in der Weise, daß sich die Optik (71) kontinuierlich radial zu der Platte bewegt; und  
Lenken des Lichtstrahls in einer radialen Richtung zu der Platte mittels einer akustooptischen Einrichtung (44), während sich die Optik (71) kontinuierlich radial zu der Platte bewegt, um den Strahl in einem konzentrischen kreisförmigen Muster auf der Platte zu halten, während jede konzentrische kreisförmige optische Servospur geätzt wird.

2. Verfahren nach Anspruch 1, wobei die Schritte der Lenkung aufweisen:

Speichern von Sätzen digitaler Lenkungssignale zum Steuern der Lenkung;  
Auswählen der Sätze unter der Steuerung eines Mikroprozessors und als Reaktion auf die radiale Position des Strahls; und  
Anlegen der Signalsätze an die akustooptische Einrichtung, um den Strahl in konzentrischen Mustern zu halten.

3. Verfahren nach Anspruch 2, ferner aufweisend:

Drehen der Platte auf einer Spindel, während die Servospuren (12) geätzt werden;  
Kodieren der radialen Position der Optik, um ein die radiale Position der Optik (71) in Bezug auf die Spindel (59) repräsentierendes Signal zu erzeugen;  
Anlegen des die radiale Position repräsentierenden Signals, um die gespeicherten digitalen Lenkungssignale auszuwählen.

4. Verfahren nach Anspruch 1, wobei der Schritt der mechanischen Bewegung der Optik (71) aufweist:

5. Verfahren nach Anspruch 1, ferner aufweisend:

Speichern von Sätzen digitaler Intensitätssignale für die Steuerung der Intensität des Lichtstrahls; und  
Anlegen der digitalen Intensitätssignale an die akustooptische Einrichtung, um die Intensität des Strahls zu steuern.

6. Verfahren nach Anspruch 5, ferner aufweisend:

Drehen der Platte auf einer Spindel (59), während die Servospuren (12) geätzt werden;  
Kodieren der radialen Position der Optik, um ein die radiale Position der Optik (71) in Bezug auf die Spindel (59) repräsentierendes Signal zu erzeugen;  
Anlegen des die radiale Position repräsentierenden Signals, um die gespeicherten digitalen Intensitätssignale auszuwählen.

7. Vorrichtung zum Ätzen mehrerer konzentrischer kreisförmiger optischer Servospuren (12) um die Rotationsachse einer magnetischen Speicherplatte (61) in Bezug auf magnetische Spuren (20) auf der Platte, mit:

einer Optik (71) zum Erzeugen eines Lichtstrahls zum Ätzen jeder der optischen Servospuren (12);

gekennzeichnet durch:

eine Einrichtung zum mechanischen Bewegen der Optik (71), welche den Lichtstrahl erzeugt, in der Weise, daß sich die Optik (71) kontinuierlich radial zu der Platte bewegt; und  
eine akustooptische Einrichtung (44) zum Lenken des Lichtstrahls in einer radialen Richtung zu der Platte, während sich die Optik (71) kontinuierlich radial zu der Platte bewegt, um den Strahl in einem konzentrischen kreisförmigen Muster auf der Platte zu halten, während jede konzentrische kreisförmige optische Servospur (12) geätzt wird.

8. Vorrichtung nach Anspruch 7, ferner mit:

einem Speicher (98) zum Speichern von Sätzen digitaler Lenkungssignale zum Steuern der Lenkung;  
einem Mikroprozessor (81) zum Auswählen von Sätzen der digitalen Lenkungssignale als Reaktion auf die radiale Position des Strahls in

Bezug auf die Platte; und  
einer Einrichtung zum Anlegen der Sätze digitaler Signale an die akustooptische Einrichtung (44), um den Strahl in konzentrischen Mustern zu halten.

5

9. Vorrichtung nach Anspruch 8, ferner mit:

einer Spindel (59) zum Drehen der Platte;  
einem Kodierer (79) zum Kodieren der radialen Position der Optik (71) in Bezug auf die Spindel (59);  
einer Einrichtung zum Anlegen der die radiale Position repräsentierenden Signals, um die gespeicherten digitalen Lenkungssignale auszuwählen.

10

15

10. Vorrichtung nach Anspruch 7, wobei die Einrichtung zum mechanischen Bewegen der Optik aufweist:

20

eine Schwingspulen-Betätigungseinrichtung (72); und  
einen geschlossenen Rückkopplungs-Regelkreis (75, 76, 77, 79) zum Zurückführen einer Positionsinformation an die Schwingspulen-Betätigungseinrichtung (72).

25

11. Vorrichtung nach Anspruch 7, ferner mit:

einem Speicher (90) zum Speichern von Sätzen digitaler Intensitätssignale für die Steuerung der Intensität des Lichtstrahls; und  
einer Einrichtung (92, 94) zum Anlegen der digitalen Intensitätssignale an die akustooptische Einrichtung (44), um die Intensität des Strahls zu steuern.

30

35

12. Vorrichtung nach Anspruch 11, ferner mit:

einer Spindel (59) zum Drehen der Platte;  
einem Kodierer (79) zum Kodieren der radialen Position der Optik (71) in Bezug auf die Spindel (59); und  
einer Einrichtung zum Anlegen der die radiale Position repräsentierenden Signals, um die gespeicherten digitalen Intensitätssignale auszuwählen.

40

45

Revendications

50

1. Un procédé de gravure d'une série de pistes optiques asservies circulaires concentriques (12) autour de l'axe de rotation d'un disque de mémoire magnétique (61) en relation avec des pistes magnétiques (20) sur ledit disque comprenant:  
une génération d'un faisceau lumineux pour graver chacune desdites pistes optiques asservies;

55

caractérisé par les étapes consistant à:

déplacer mécaniquement l'optique (71) qui engendre ledit faisceau lumineux de façon que ledit optique (71) est déplacée en continu radialement par rapport audit disque; et  
régler ledit faisceau lumineux dans une direction radiale dudit disque au moyen d'un dispositif acousto-optique (44) au fur et à mesure que l'optique (71) est déplacée en continu radialement par rapport au disque afin de maintenir ledit faisceau dans une configuration circulaire concentrique sur le disque tandis qu'il grave chacune desdites pistes optiques asservies circulaires concentriques.

2. Le procédé selon la revendication 1 dans lequel les étapes de réglage comprennent les étapes consistant à:

mémoriser des ensembles de signaux numériques de réglage pour commander ledit réglage; sélectionner lesdits ensembles sous commande de microprocesseur et en réponse à la position radiale dudit faisceau; et  
appliquer au dispositif acousto-optique lesdits ensembles de signaux afin de maintenir ledit faisceau en configurations concentriques.

3. Le procédé selon la revendication 2 qui comprend en outre les étapes consistant à:

faire tourner ledit disque sur une broche tandis que lesdites pistes asservies (12) sont gravées; coder la position radiale de ladite optique afin de produire un signal représentant la position radiale de ladite optique (71) par rapport à ladite broche (59); et  
appliquer ledit signal représentant une position radiale pour sélectionner les signaux numériques de réglage mémorisés.

4. Le procédé selon la revendication 1, dans lequel l'étape de déplacement mécanique de l'optique (71) comprend les étapes consistant à:

déplacer ladite optique (71) au moyen d'un actionneur (72) à bobine acoustique; et  
envoyer en rétroaction une information de position, en commande en boucle fermée dudit actionneur (72) à bobine acoustique.

5. Le procédé selon la revendication 1 qui comprend en outre les étapes consistant à:

mémoriser des ensembles de signaux numériques d'intensité pour commander l'intensité dudit faisceau lumineux; et

appliquer audit dispositif acousto-optique lesdits signaux numériques d'intensité afin de commander l'intensité dudit faisceau.

6. Le procédé selon la revendication 5 qui comprend en outre les étapes consistant à:

faire tourner ledit disque sur une broche (59) tandis que lesdites pistes asservies (12) sont gravées;  
coder la position radiale de ladite optique afin de produire un signal représentant la position radiale de ladite optique (71) par rapport à ladite broche (59); et  
appliquer ledit signal représentant une position radiale pour sélectionner les signaux numériques d'intensité mémorisés.

7. Appareil de gravure d'une série de pistes optiques asservies circulaires concentriques (12) autour de l'axe de rotation d'un disque de mémoire magnétique (61) en relation avec des pistes magnétiques (20) sur ledit disque comprenant:

une optique (71) de génération d'un faisceau lumineux pour graver chacune desdites pistes optiques asservies (12); caractérisé par:  
un moyen de déplacement mécanique de ladite optique (71) qui engendre ledit faisceau lumineux de façon que ladite optique (71) est déplacée en continu radialement par rapport audit disque; et  
un dispositif acousto-optique (44) pour régler ledit faisceau lumineux dans une direction radiale dudit disque tandis que ladite optique (71) est déplacée en continu radialement par rapport audit disque afin de maintenir ledit faisceau dans une configuration circulaire concentrique sur le disque pendant la gravure de chacune desdites pistes optiques asservies circulaires concentriques (12).

8. L'appareil selon la revendication 7 qui comprend en outre:

une mémoire (98) pour mémoriser des ensembles de signaux numériques de réglage pour commander ledit réglage;  
un microprocesseur (81) pour sélectionner des ensembles desdits signaux numériques de réglage en réponse à la position radiale dudit faisceau par rapport audit disque; et  
un moyen d'application desdits ensembles de signaux numériques audit dispositif acousto-optique (44) afin de maintenir ledit faisceau en configurations concentriques.

9. L'appareil selon la revendication 8 qui comprend en

outre:

une broche (59) pour faire tourner ledit disque;  
un codeur (79) pour coder la position radiale de ladite optique (71) par rapport à ladite broche (59); et  
un moyen d'application dudit signal représentant une position radiale afin de sélectionner les signaux numériques de réglage mémorisés.

10. L'appareil selon la revendication 7, dans lequel ledit moyen de déplacement mécanique de ladite optique comprend:

un actionneur (72) à bobine acoustique; et  
une commande de rétroaction en boucle fermée (75, 76, 77, 79) pour envoyer en rétroaction une information de position audit actionneur (72) à bobine acoustique.

11. L'appareil selon la revendication 7 qui comprend en outre:

une mémoire (90) pour mémoriser des ensembles de signaux numériques d'intensité pour commander l'intensité dudit faisceau lumineux; et  
un moyen (92, 94) d'application desdits signaux numériques d'intensité audit dispositif acousto-optique (44) pour commander l'intensité dudit faisceau.

12. L'appareil selon la revendication 11 qui comprend en outre

une broche (59) pour faire tourner ledit disque;  
un codeur (79) pour coder la position radiale de ladite optique (71) par rapport à ladite broche (59); et  
un moyen d'application dudit signal représentant une position radiale afin de sélectionner les signaux numériques d'intensité mémorisés.

FIG. 1

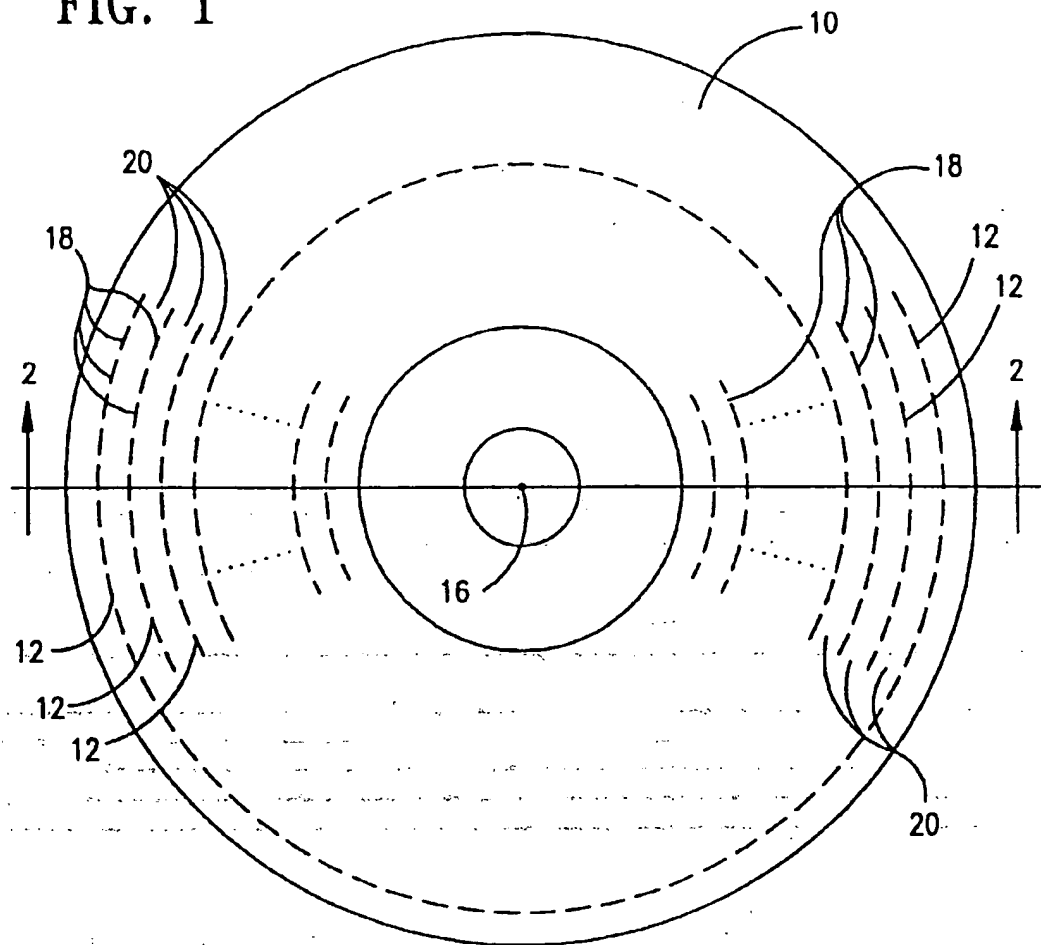


FIG. 2

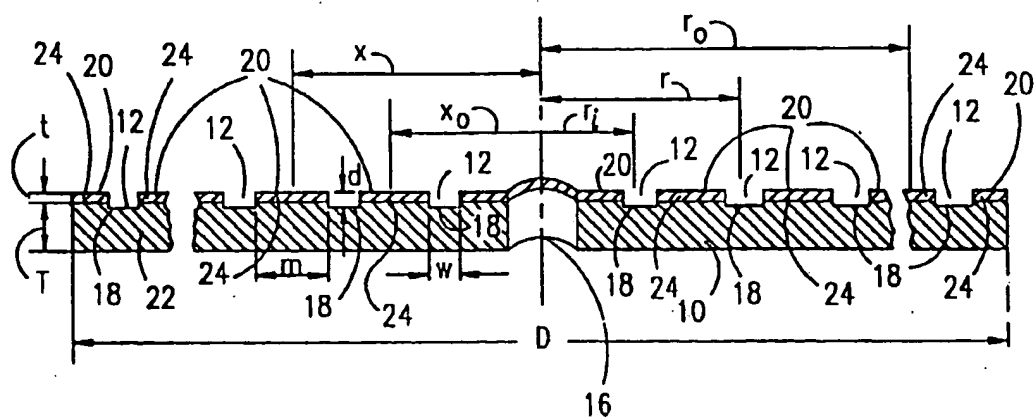


FIG. 3

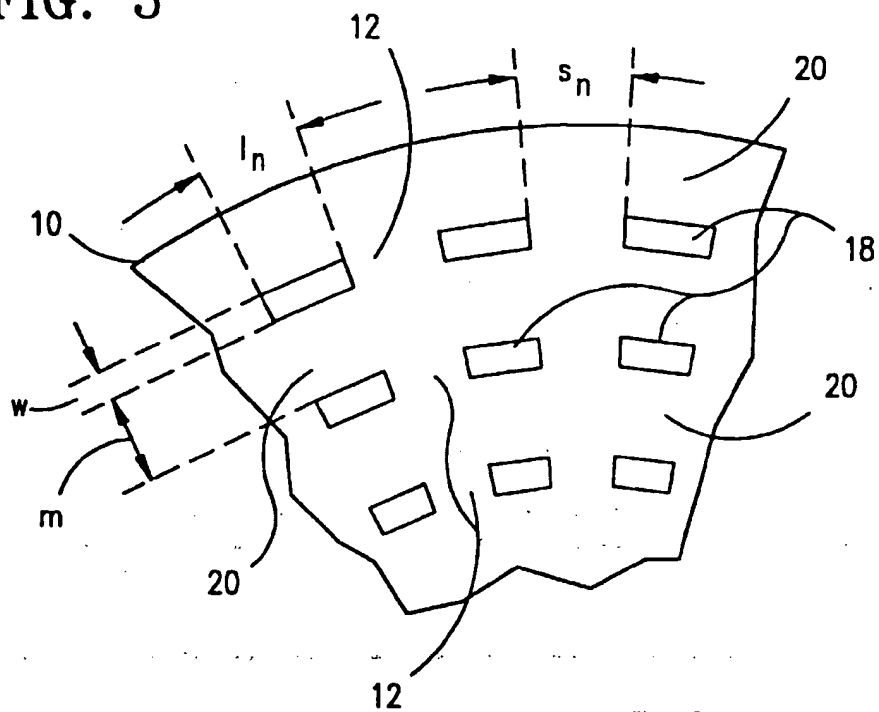
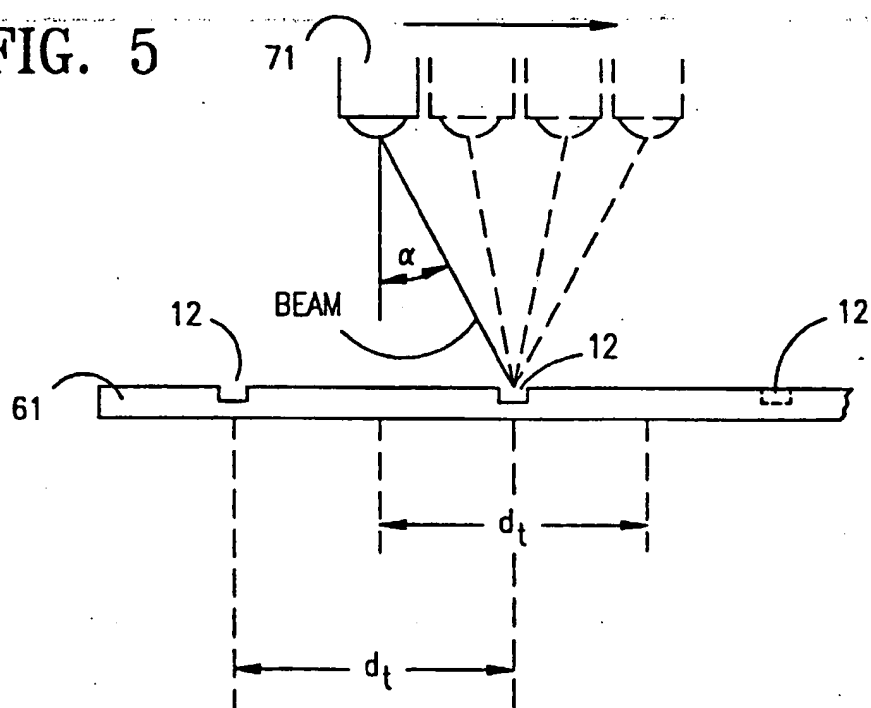
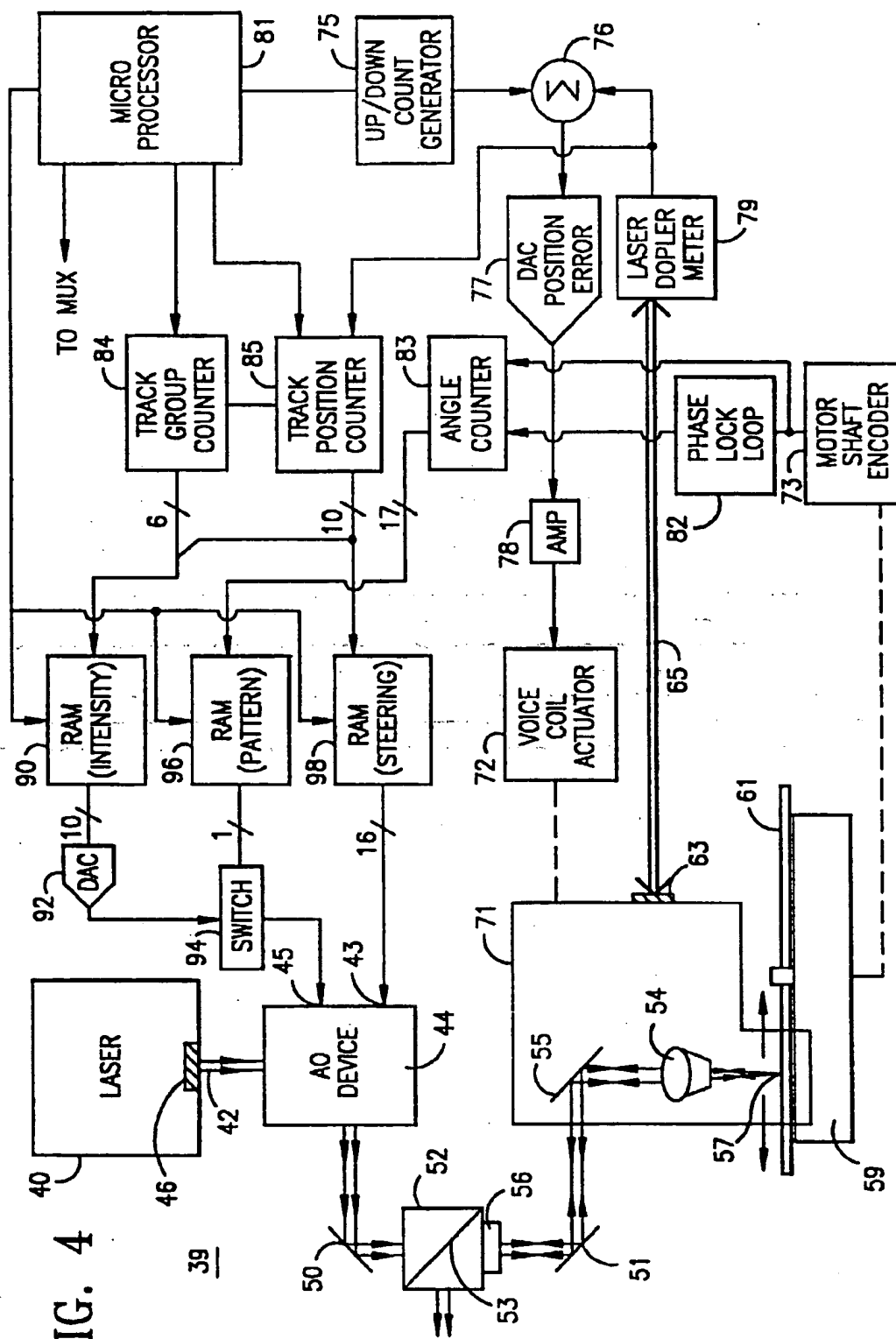


FIG. 5





**FIG. 4**

FIG. 6

